

Date: Wednesday, 10/31/2007 3:26:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35495	
Estimate Number : 10330	
P.O. Number :	Part Number : D2746
This Issue : 10/31/2007 S.O. No. :	Drawing Number : D2746 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 32991	Material :
Written By :	Due Date : 11/28/2007 Qty: 30 Um: Each
Checked & Approved By : <u>10/31/07</u>	
Comment : Est Rev: D 02.10.24 Re-format KJ	
Est Rev: E 06-03-21 as Per Rev C JLM	
Est Rev: F 06-06-12 Now On Waterjet JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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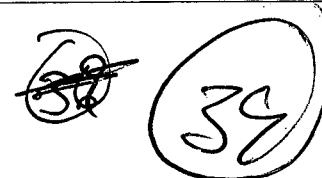
Comment: Qty.: 0.4263 sf(s)/Unit Total : 12.7890 sf(s)
 1010/1025/A21/6aA .040" SHEET
 (M1010S20GA)
 Batch: 101069 B 07-11-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2746 B 07-11-6
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary B 07-11-6



3.0-	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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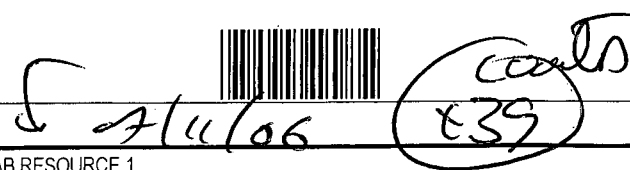


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK



5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

n/g 5/11/06

Due at start 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/31/2007 3:26:46 PM
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Process Sheet

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Drawing Name: WEARSHOE

Job Number: 35495

Part Number: D2746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261and DT8326

2-Form joggle on Punch as per Dwg D2746 using Jig DT8158Identify as D2746

07/11/13 (39)

93

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/13 (39)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

M-L 07/11/13

(39X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/11/14 (39)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 18

M-L 07/11/14

(39X)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.15

Job Completion



U 07.11.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

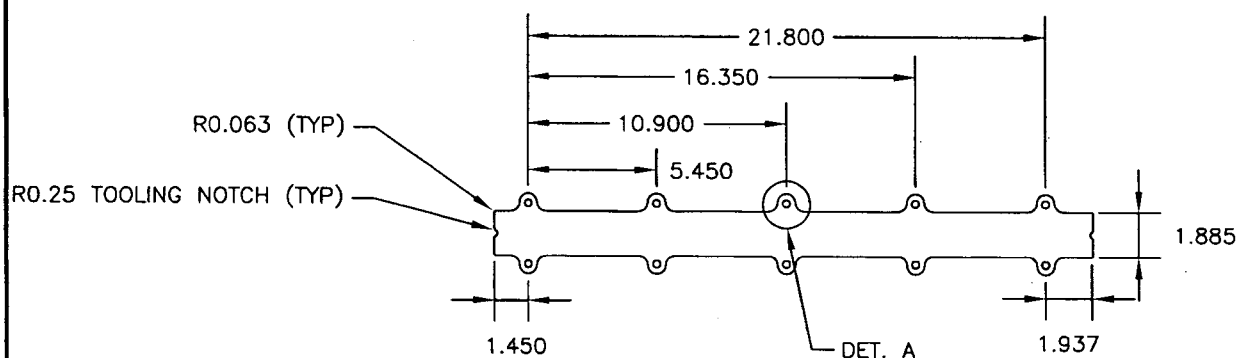
NOTE: Date & initial all entries



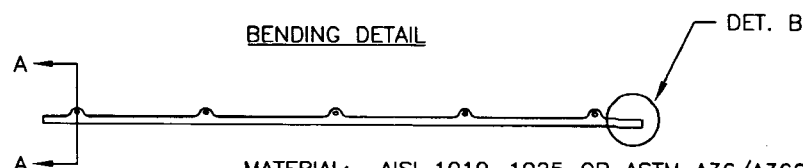
RELEASED
06-01-12

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
P41	P41	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2746	SHEET 1 OF 1
DATE		TITLE	SCALE
06.01.12		WEARSHOE	1:8
A	98.04.16	NEW ISSUE	
B	98.08.18	RE-DESIGN	
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT	

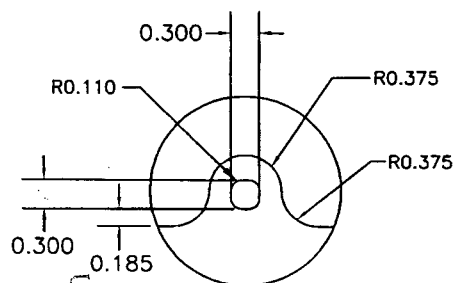
FLAT PATTERN



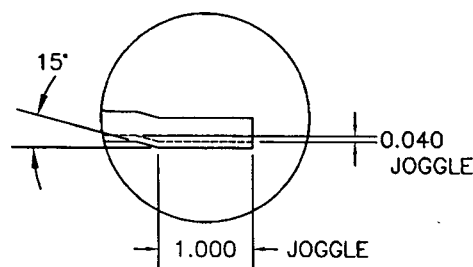
BENDING DETAIL



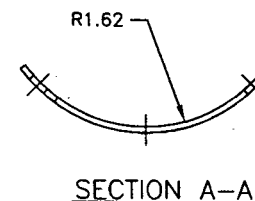
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)



DETAIL A



DETAIL B



NOTES:
1) UNCONTROLLED COPY
2) SUBJECT TO AMENDMENT
3) WITHOUT NOTICE
4) RETURN TO
5) ENGINEERING
6) MATERIAL:
7) FINISH:
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
10) THIS PART CAN BE MADE BY MODIFYING D2656-21

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9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
10) THIS PART CAN BE MADE BY MODIFYING D2656-21